Work	Order	ID	57553
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April 8, 2010 9:55:23 AM



Page 1

D3763-3 Accept Setup Start Item ID: **Revision ID:** Stop Tube Item Name: Start Qty: 4.00 4/08/10 **Start Date: Cust Item ID:** Rea'd Otv: 4.00 Required Date: 4/16/10 **Customer:** Reference: 10.04. Run Start Tooling: Date: Approvals: Process Plan: Date: Stop SPC (Y/N): QC: Date: Date: Reject Sequence ID/ Operation Set Up/ Draw Draw Plan Accept Reject Insp. **Work Center ID Run Hours** Number Rev. Code Qty Qty Number Stamp Description Draw Nbr **Revision Nbr** D3763 Rev B 0.00 100 and 10/04/12 DOOSAN LATHE 0.00 Doosan _ & Dwg D3763 Rev: <u>B</u> □2-Deburr 1- Turn as per Folio FA751 Rev: 4A Doosan Lathe per dwg D3763 and idoula QC2- Inspect parts off machine FAI/FAIB 0.00 110 0.00 QC Memo Quality Control 0.00 120 OC8- Inspect parts - second check B.A 10/04/12 QC Memo Quality Control

Dart Aerospace Ltd

W/O:			W	ORK ORDER CHANG	ES			
DATE	STEP	PR	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
							i rod wigi	
Part No	:	PAR #:	Fault Cate	gory:	_ NCR: Yes	No DQA:	Date: _	
		solution:						
NCR:			WORK ORD	ER NON-CONFORMA	ANCE (NCR)		
DATE	STEP	Description of NC		Corrective Action Section		Verification	Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
								-
	1 1					Ī	i	ľ

NOTE: Date & initial all entries

Work Order ID 57553

April 8, 2010 9:55:23 AM



Page 2

Item ID:

D3763-3

Accept

Setup Start



Revision ID:

Start Date:

Item Name: Tube

Required Date: 4/16/10

4/08/10

QC:

Start Qty: 4.00

Req'd Qty: 4.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Date:_____

Tooling:

SPC (Y/N):

Date:

Date:

Start

Stop

Stop



Sequence ID/ Work Center ID

130

Packaging

Operation Description

Identify as per dwg & Stock Location: 25/

Memo

Memo

Set Up/ **Run Hours**

0.00

Draw Number Draw Rev.

Plan Qty Code

Reject Accept Qty

Run

Reject Number

Insp. Stamp

Packaging

0.00

will

140

QC21- Final Inspection - Work Order Release

0.00

0.00

BS 10-4-13

Quality Control

Dart Aerospace Ltd

W/O:			W	ORK ORDER CHANG	GES	 		<u> </u>		
DATE	STEP	PR	OCEDURE CH			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	egory:	_ NCR	: Yes	No DQ	A:	Date:	
	Res	solution:	Disposition	on:	QA:	N/C CId	sed:		Date:	
NCR:			WORK ORD	ER NON-CONFORM	ANCE	(NCR)			
DATE	STEP	Description of NC Section A	Initial	Action Description	tion B	Sign &	Verific Secti		Approval Chief Eng	Approval QC Inspector
			Chief Eng	Chief Eng		Date				-
							·			
				•						

NOTE: Date & initial all entries

Picklist Print

April 8, 2010 9:55:22 AM

Work Order ID: 57553

Parent Item:

Comments:

D3763-3

Parent Item Name:

Tube

IPP Rev:A

08-05-23 new issue

DD verified by:JLM

Start Date: 4/08/10

Required Date: 4/16/10

Page 1

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6R1.250		Purchased	No			100	f	56.9660	0.4589			

6061-T6 Round Bar 1.250

Warehouse	Loc Qty	Loc Code	
Location			
Main Warehouse			
MAT013	56.966		
113457	36.966		
113550	20		

.4589 -ml 10/04/12

Dart Aerospace Ltd

W/O:			WC	RK ORDER CHAN	GES						
DATE	STEP	PRO	OCEDURE CHA	NGE	By Date Qty Chief				Approval Chief Eng / Prod Mgr	Chief Eng /	
					!						
Part No	:	PAR #:	Fault Cate	gory:	NCF	l: Yes	No DQ /	4:	Date:		
		solution:									
NCR:		,	WORK ORDE	ER NON-CONFORM	IANCE	(NCR)				
DATE	STEP	Description of NC	Initial	Corrective Action Se Action Description	ction B	Sign &	Verific		Approval	Approval	
		Section A	Chief Eng	Chief Eng		Date	Secti	on C	Chief Eng	QC Inspector	
										-	
_											
									i		
									:		

NOTE: Date & initial all entries

	Work Order:	57553
Description: Tube	Part Number:	D3763-3
Inspection Dwg: D3763 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X Fi	irst Article	Prof	otype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.221	+0.005/-0.001	Ø.223				
0.66	+/-0.030	.858				
1.31	+/-0.030	1.311				·
0.66	+/-0.030	-658				
0.05 x 45°	+/-0.030 x +/-0.5°	050 X450				
Ø0.201	+0.005/-0.001	8.202	/			
Ø1.010	+0.010/-0.000	B.202 B1.012				
Ø1.16	+/-0.030	81.160	l			
				,		

Measured by:	and	Audited by:	Prototype Approval:	N/A
Date:	10/04/12	Date: 10/04/12	Date:	N/A

Rev	Date	Change	Revised	by₁∧	Approved
Α	08.09.04	New Issue	KJ/DD	OXX	X



Lean Is...

- "LEAN IS from an operations perspective... a system that cuts costs & inventories rapidly to free cash, which is critical in a slow economy. It also supports growth by improving productivity and quality, reducing lead times and freeing huge amounts of resources.
- Lean aims at reducing (if not eliminating) none value added activities in business processes.
- It's not a project.

w/o 57553 Ø 1.010 +0.010 -0.000 Ø0.221 B С 0.66 Ø1.16 B 0.66 -0.05 X 45° CHAMFER 2 PL Ø0.201 THRU B D3763-3 TUBE

NOTES: 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6510/T6511/T62) ALUMINUM ROUND BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF. DART SPEC M6061T6R) (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-/ 2) FINISH: NONE 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED 4) UNITS: INCHES UNLESS OTHERWISE NOTED 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX 6) IDENTIFICATION: N/A 7) WEIGHT: 0.01 lbs

7

DESIGN HS DART AEROSPACE LTD DRAWN HS HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. B D3763 MFG, APPR. SHEET 6 OF 9 TITLE APPROVED SCALE DE APPR NTS DATE 08.06.23

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HOT TO SE USED FOR AIR PARCISES OR COMPLICATION OF ANY THE RESONANT TOUR
WARTERS FEMILES

5



Lean is...

- Promote customer-orientation rather than resource-orientation (produce for sales not for stock).
- A highly evolved method of managing an organization to improve the productivity, efficiency and quality of its products or services.
- Transforms how the company operates and how employees think about their work. Don't work harder but smarter by transferring your energy from the NVA to the VA activities.
- Has no end (there is no "done").